

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021999**Date Inspected:** 14-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. An Qing Xian.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Chang xing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

OBG 14EAST

SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 051359 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13BE. Joint identified as SEG3009E-003. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1. For more information see attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067610, 068097, 037743 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13AE Deck panel to Edge panel. Joint identified as SEG3007AB-096. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1. For more information see attached picture number 2.

This QA Inspector observed ZPMC qualified welding personnel identified as 068924, 068917, 037748 Perform

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Shielded Metal Arc Welding (SMAW) on OBG Segment 13AE Deck panel to Deck panel. Joint identified as SEG3007-010. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-B-U2-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067656 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13. Joint identified as SEG3009C-242, 243. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

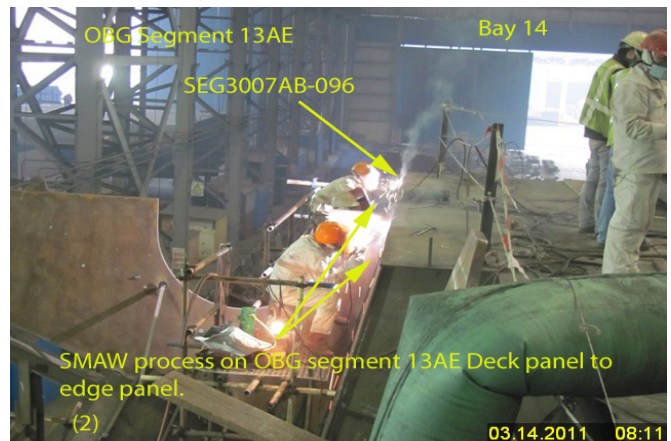
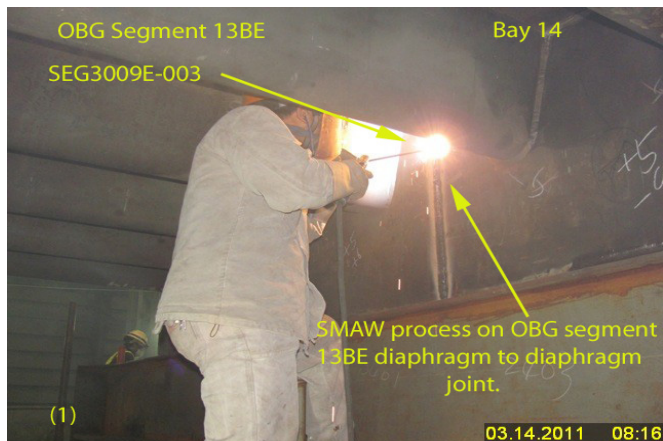
This QA Inspector observed ZPMC qualified welding personnel identified as 066326 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13BE+13CE Deck panel to Deck panel. Joint identified as OBE13A-009. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

SAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 062406 Perform Submerged Arc Welding (SAW) on OBG Segment 13AE Deck panel to Deck panel. Joint identified as SEG3007-010. ZPMC CWI Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

This QA Inspector performed visual inspection and dimensions on cope hole area of Anchor plate AP3031 of OBG segment 14 East.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho: 150002048250, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer